

Work Order ID 59637

Wednesday, June 09, 2010 9:45:43 AM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Item Name: Handle Weldment

Stop



Start Date: 6/9/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-6-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2530	Rev B

100 0.00



Small Fab

Small Fab

Memo

Small Fab

1-Cut to length as per Dwg D2536
2-Deburr

0.00

SAD 10-06-09

(8)

110 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

Quality Control

0.00

S.0606/07

(x2)

120 0.00



Weld per dwg A/R S.S. rod Batch: M108160

Large Fab

Memo

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

0.00

10-6-23

(x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 8:25 OVEN TEMPERATURE: 300° FINISH TIME: 8:55	0.00 0.00							

⑧ 10 10.06.23

78

8' 16L 10-6-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10 06 24 (8)

170

Identify as per dwg & Stock Location: 57506 0.00



Packaging

Memo

0.00

Packaging

6/14/25 (5)

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/06/28
CZ 10/6/25

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Picklist Print

Wednesday, June 09, 2010 9:45:47 AM

Page 1

Work Order ID: 59637

Parent Item: D2530

Parent Item Name: Handle Weldment


Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM

Start Date: 6/9/2010

Required Date: 6/17/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	276.3000	2.9145	24.54316			
													
304 RD Tube .750 x .049W													

Location

Loc Qty

Loc Code

MAT

248.4365

108498

0

114482

6.6065

114852

241.83

MAT017

27.8635

109314

9.33

110113

5.29

112800

13.2435

24.54316

D2534

Manufactured

No

120

Each

1.0000

2

16



Lock Plate

Location

Loc Qty

Loc Code

WA

1

58332

1

B59871

EL 10-6-23

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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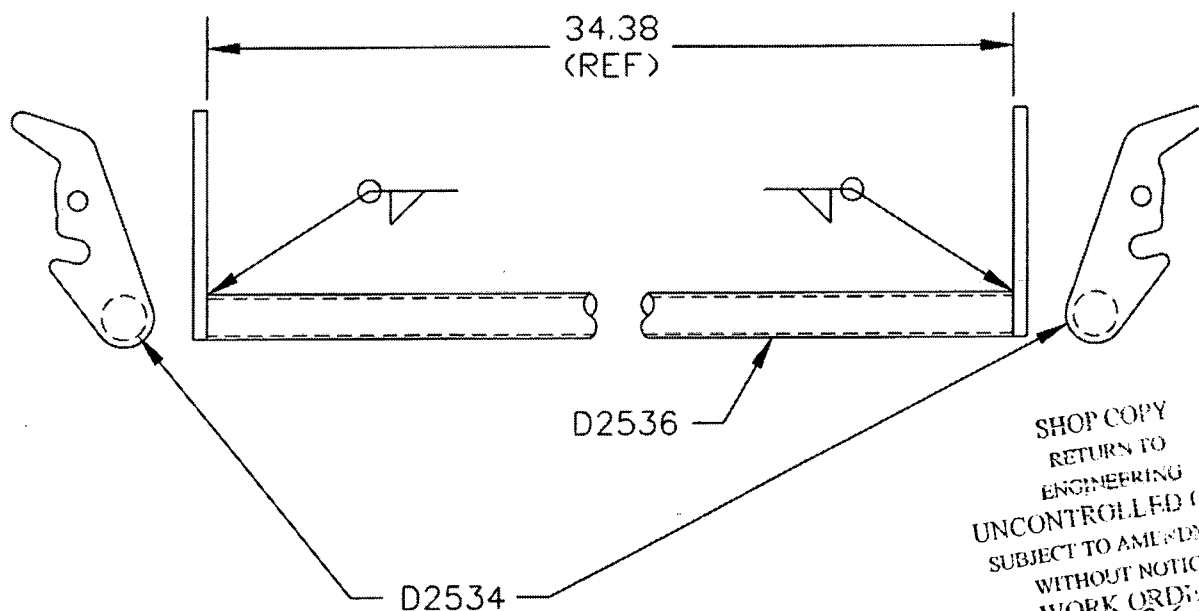
DART

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT SCALE	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59637

PS10-6-09

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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